

इंटरनेट

मानक

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“जानने का अधिकार, जीने का अधिकार”

Mazdoor Kisan Shakti Sangathan

“The Right to Information, The Right to Live”

“पुराने को छोड़ नये के तरफ”

Jawaharlal Nehru

“Step Out From the Old to the New”

IS 8669 (1992): Hexagon drive ends for power tools -
Dimensions [PGD 5: Assembly Hand Tools]



“ज्ञान से एक नये भारत का निर्माण”

Satyanarayan Gangaram Pitroda

“Invent a New India Using Knowledge”



“ज्ञान एक ऐसा खजाना है जो कभी चुराया नहीं जा सकता है”

Bhartrhari—Nitiśatakam

“Knowledge is such a treasure which cannot be stolen”

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भारतीय मानक

पावर औजारों के लिए षटकोणीय चालन सिरे — आयाम

(पहला पुनरीक्षण)

Indian Standard

HEXAGON DRIVE ENDS FOR POWER
TOOLS — DIMENSIONS

(*First Revision*)

UDC 621.883.14

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BUREAU OF INDIAN STANDARDS
MANAK BHAVAN, 9 BAHADUR SHAH ZAFAR MARG
NEW DELHI 110002

April 1992

Price Group 2

FOREWORD

This Indian Standard (First Revision) was adopted by the Bureau of Indian Standards, after the draft finalized by Assembly Hand Tools Sectional Committee had been approved by the Production Engineering Division Council.

This standard was first issued in 1977 based on ISO 1173 : 1975. Consequent on the revision of ISO Standard, this standard has been revised. Nominal dimension 16 has been deleted and other dimensions have been aligned with international practices. Separation force and minimum test torque values have been included.

Maximum and minimum dimensions of hexagon have been selected to allow interchangeability between metric and inch products. Deviations between maximum and minimum dimensions of s_1 and s_2 correspond to tolerances of grade 10 (See IS 919 : 1969 'Limits and fits for engineering').

Dimension 'e' has been calculated by using the formula $e = 1.13 s$.

While preparing this standard assistance has been derived from ISO 1173 : 1980 Assembly tools for bolts and screws — Hexagon drive ends for hand and machine operated screwdriver bits issued by International Organization for Standardization (ISO).

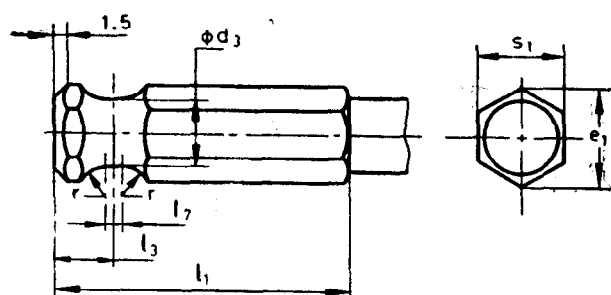
For the purpose of deciding whether a particular requirement of this standard is complied with, the final value, observed or calculated, expressing the result of a test, shall be rounded off in accordance with IS 2 : 1960 'Rules for rounding off numerical values (*revised*)'. The number of significant places retained in the rounded off value should be the same as that of the specified value in this standard.

(*First Revision*)

2 DIMENSIONS

2.1 Male Hexagons

Technical drawing of a shaft-hub assembly. The left part is a side view showing a shaft of diameter $\phi 5$ with a hole of diameter $\phi 2$ at distance l_3 from the left end. The hole is located at distance X from the shaft end and X from the hub end. The hub has a total length l_1 and a fillet radius $R 0.6 \text{ min.}$ The right part is a cross-section labeled $X-X$ showing the hole's position relative to the shaft end (S_1), the hole center ($\phi 2$), and the hub end (e_1).

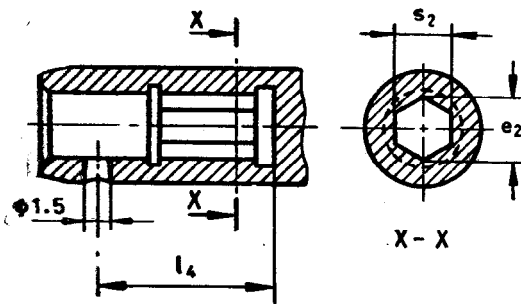


FORM C

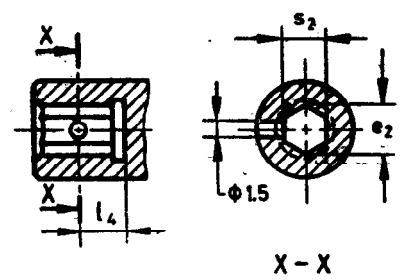
1

2.2 Female Hexagons

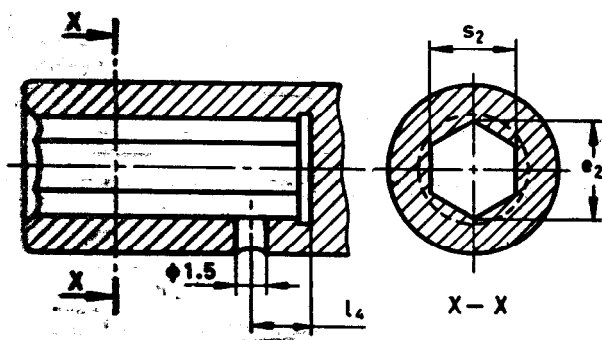
All dimensions in millimetres.



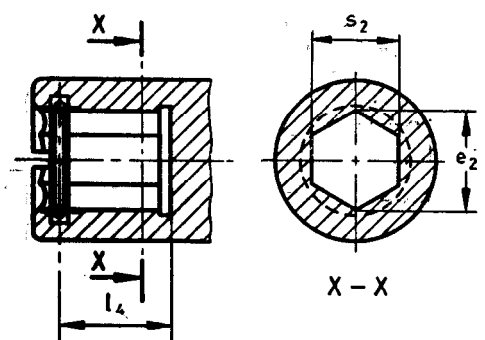
FORM B



FORM D



FORM F



Form	s ₂			e ₂ Min	l ₄ +0.1 0
	Nom	Max	Min		
B	3	3.06	3.02	3.41	11.9
	5.5	5.578	5.53	6.25	16
D	4	4.04	3.992	4.51	4
	8.3	6.448	6.39	7.22	8.2
	8	8.029	7.97	9	10.2
F	6.3	6.448	6.39	7.22	9.5
	11.2	11.232	11.162	12.61	6.7

3 SEPARATION FORCE

The force required to separate the male and female parts shall have a minimum value of 2.5 N.

4 MINIMUM TEST TORQUES

<i>Form</i>	<i>Nominal Dimension</i>	<i>Minimum Test Torque</i>
	mm	Nm
A and B	3	7.6
	5.5	47
C and D	4	18
	6.3	71
	8	144
E and F	6.3	71
	11.2	396

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